

CLAIMS

- 1- Device (100) for assembling a pneumatic booster (200),
5 characterized in that it comprises
- a fixed cylindrical support (101) whose internal volume (102) is greater than the volume of a cover (203) of the booster, the cover being housed in the support,
 - a cylindrical cap (104) whose internal volume (107) is greater than
10 the volume of a cylinder (206) of the booster, said cap imposing an axial load on the cylinder,
 - at least one set of rollers (109A, 109B), rotated by a motor, the rollers rotating at least partially about the support.
- 2- Device according to Claim 1, characterized in that it is furnished
15 with a first set of rollers (109A) and a second set of rollers (109B), the two sets of rollers rotating at least partially about the support.
- 3- Device according to one of Claims 1 or 2, characterized in that it is furnished with a center positioner (106) lying on an upper end (103) of the fixed support, the cover lying on the center positioner, the center positioner
20 having a ring shape, an internal diameter of the center positioner being approximately equal to a diameter of the booster cover.
- 4- Device according to one of Claims 2 to 3, characterized in that the first and second rollers are alternated.
- 5- Device according to one of Claims 2 to 4, characterized in that the
25 first set of rollers is furnished with three rollers, and in that the second set of rollers is furnished with three rollers, the first rollers being spaced at 120° from one another, and being spaced at 60° from the second rollers.
- 6- Device according to one of Claims 2 to 5, characterized in that the first rollers are furnished with a bevel (113A), said bevel having an angle of
30 attack (114A) lying between 115 and 135°, and in that the second rollers are each furnished with a bevel (113B), said bevel having an angle of attack (114B) lying between 80 and 90°.
- 7- Device according to Claim 6, characterized in that the angle of
35 attack of the bevels of the first rollers is 120°, and in that the angle of attack of the bevels of the second rollers is 85°.

8- Device according to one of Claims 2 to 7, characterized in that it is furnished with a gearing element (110) driving the rollers in rotation, and in that the gearing element is furnished with two gear wheels, a number of teeth of a first gear wheel (111) of the gearing element, driving in rotation the two
5 sets of rollers about the booster, being different from a number of teeth of a second gear wheel (112) of said gearing element, the second wheel imposing by means of an eccentric (118) an oscillating radial movement of the rollers relative to an axis (C) of the support.

9- Method of swaging a booster, characterized in that it comprises the
10 steps

- a cover (203) of a booster (200) is inserted into a support (101) of a swaging device (100), a top end (204) of a wall (205) of the cover resting on a top end (103) of an internal wall of the support,

- a cylinder (206) of the booster is placed on the cover, a bottom end
15 (208) of a wall (209) of the cylinder resting on the top end of the wall of the cover,

- a cap (104) of the swaging device is placed on the support, a bottom end (108) of the cap compressing the bottom end of the wall of the cylinder onto the top end of the wall of the cover,

- a motor is actuated,
20 - the swaging rollers (109) are made to rotate about the booster, by means of the motor,

- the bottom end of the wall of the cylinder is swaged continuously onto the top end of the wall of the cover.

25 10- Method according to Claim 9, characterized in that it comprises the step

- the rollers are made to make a radially oscillating movement relative to an axis (C) of the support.

30 11- Method according to Claim 10, characterized in that it comprises the step

- the rollers are made to make a radially oscillating movement relative to the axis (C) of the support, by means of an eccentric (118) driven by a gearing element (110).

35 12- Method according to one of Claims 9 to 11, characterized in that it comprises the step

- the bottom end of the wall of the cylinder is swaged onto the top end of the wall of the cover by successively applying the rollers (109A) furnished with a first angle of attack (114A) and rollers (109B) furnished with a second angle of attack (114B), the first angle of attack being greater than the second angle of attack.
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13- Pneumatic booster (200) for a motor vehicle braking device, characterized in that it is obtained by a method according to one of Claims 9 to 12.